

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D2590-041	SKIDTUBE ASSEMBLY
1		X	D2590-043	SKIDTUBE ASSEMBLY
2	1	1	D2500-1-190	EXTRUSION
3		16	D2570	BUSHING
4	1	1	D2576-3	STEP
5	10	4	D2594-1	PLUG
6	10	4	D2594-3	O-RING
7	1	1	D2597	204 WEB
8	1	1	D2855	AFT CAP
9	1		D3564-7	WEARSHOE
10	1		D3564-9	WEARSHOE
11	1		D3564-11	WEARSHOE
12	1		D3564-13	WEARSHOE
13	17	22	D4202-1	SPACER
14		1	D4408-041	WEARPLATE ASSEMBLY
15		1	D4408-043	WEARPLATE ASSEMBLY
16	44		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
17	44		AN3C4A	BOLT
18	2	2	AN3-5A	BOLT
19		8	AN4-45A	BOLT
20	44		NAS1149C0332R	WASHER (AN960C10L)
21	2	2	NAS1149D0332J	WASHER (AN960JD10L)
22		8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

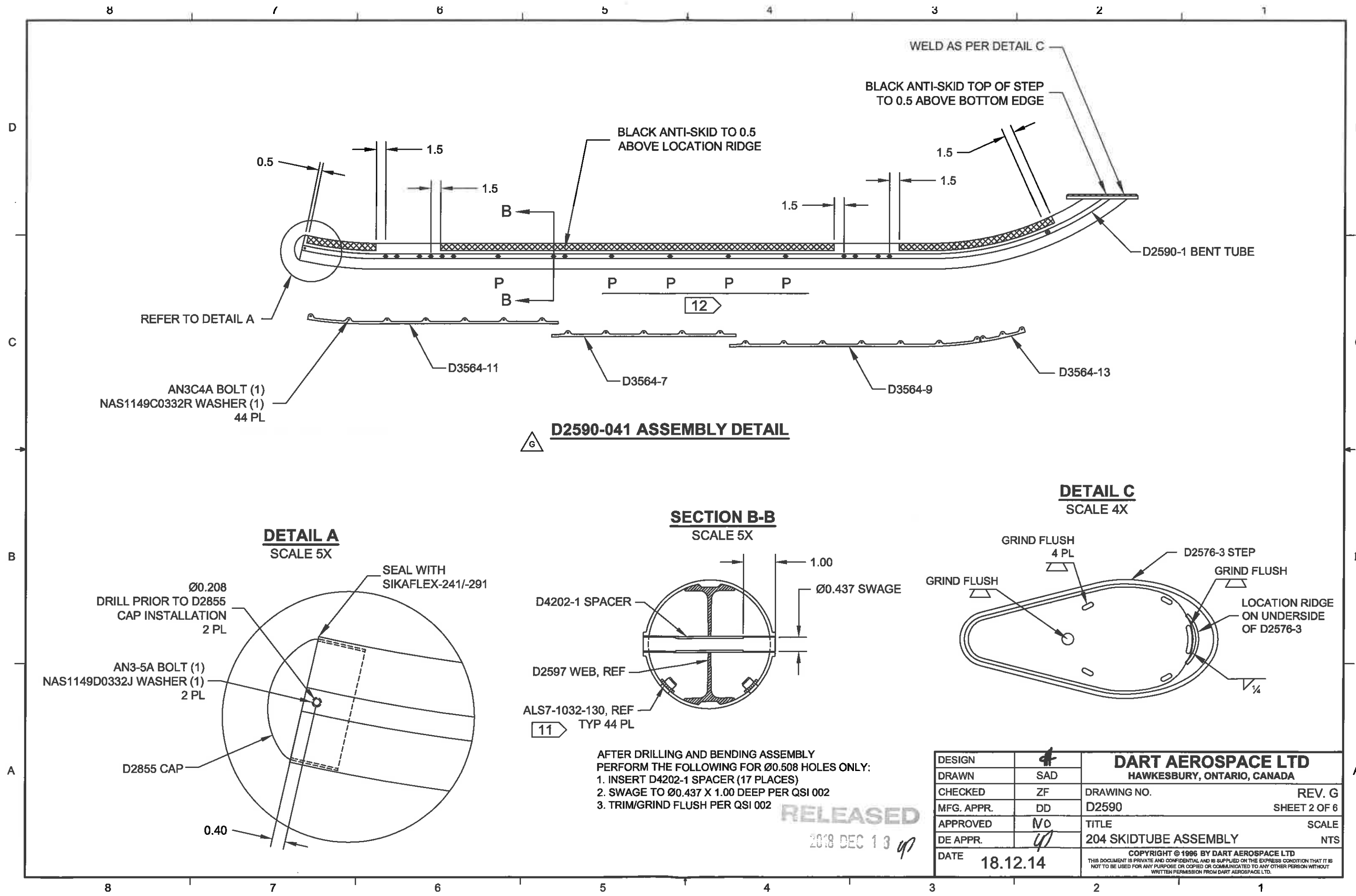
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB
POWDER COAT ASSEMBLY GLOSS WHITE 4.3.5.1 PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2590-041 = 30.6 lbs
D2590-043 = 33.3 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8218 ONLY FOR D2590-041 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (44 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES FOR D2590-041 AND 8 PLACES FOR D2590-043).
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.

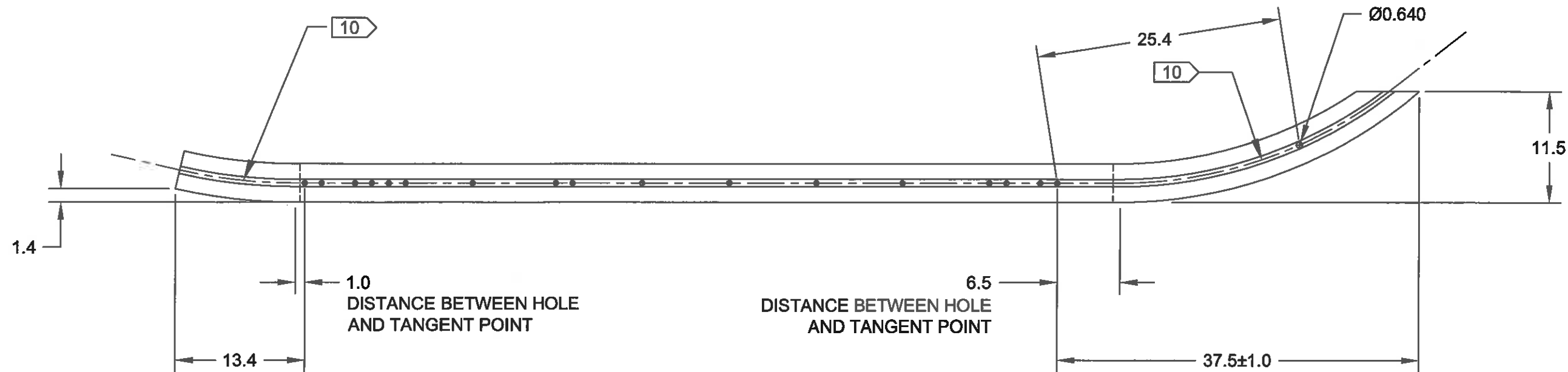
G	SHEET 1 : PL DELETE D3566-1/-7/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEET 2 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	18.12.14
F	INCORPORATE DEO D2590-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2590-043; DT8218 WAS TD2577-204 (ZN C4-1); REFORMATTED DRAWING TO CURRENT STANDARDS	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.28
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>df</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	ZF	DRAWING NO.	REV. G
MFG. APPR.	DD	D2590	SHEET 1 OF 6
APPROVED	<i>No</i>	TITLE	SCALE
DE APPR.	<i>df</i>	204 SKIDTUBE ASSEMBLY	NTS
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2018 DEC 18

EcN 18-805

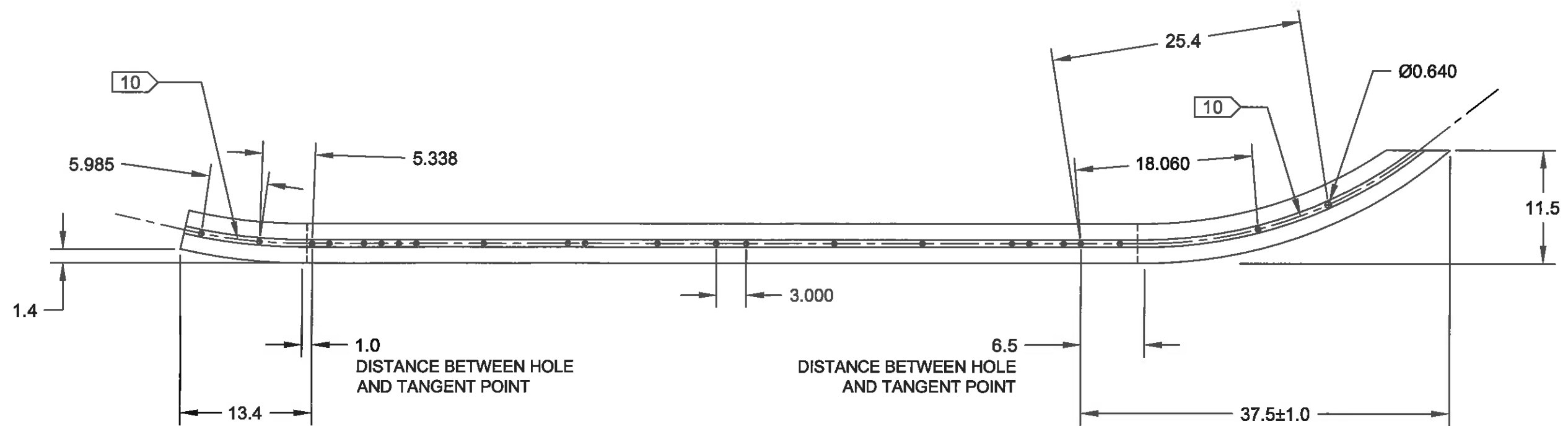




D2590-1 BENT TUBE
(MAKE FROM D2590-101 TUBE)

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2018 DEC 13 *qf*

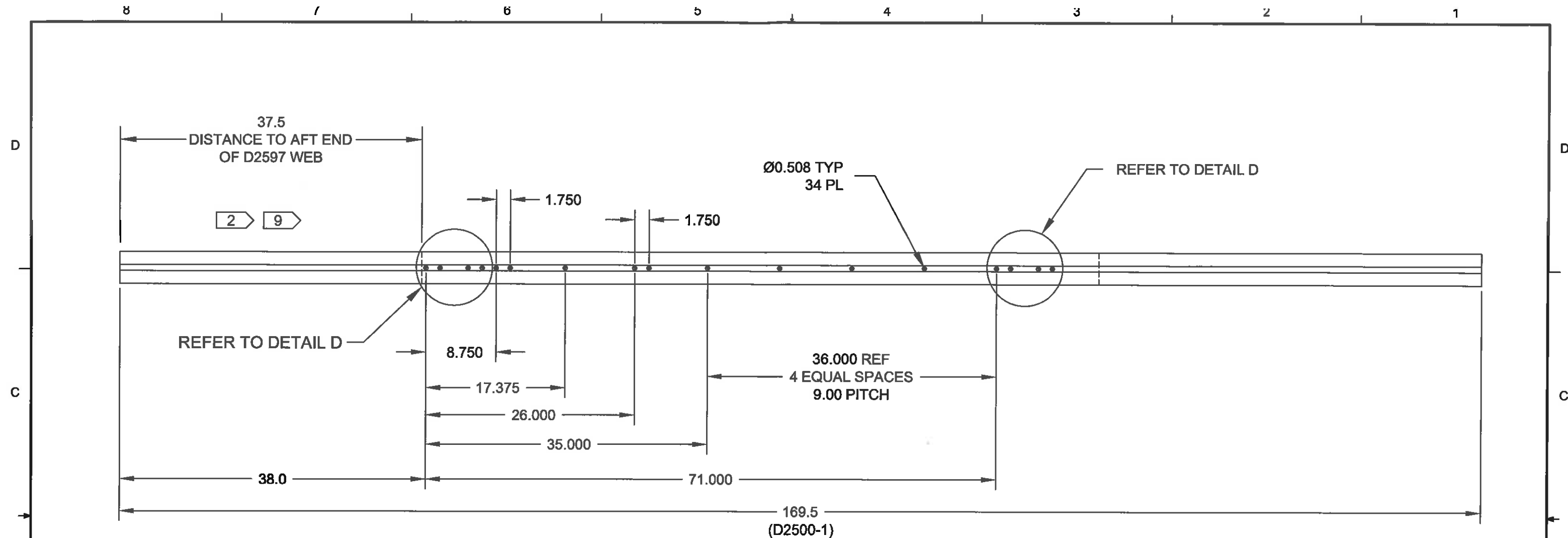
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DRAWN	SAD		
CHECKED	ZF	DRAWING NO.	REV. G
MFG. APPR.	DD	D2590	SHEET 3 OF 6
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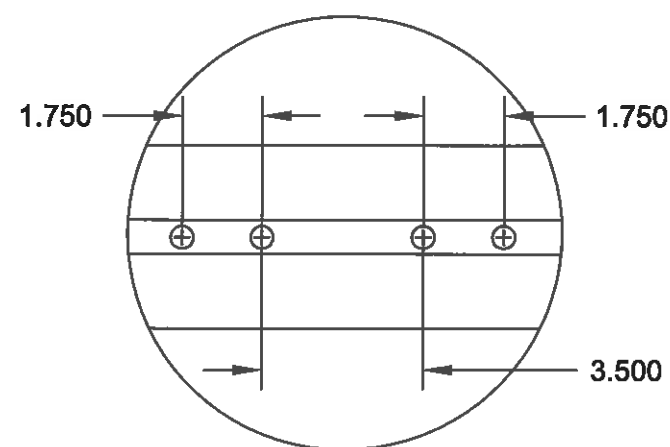
D2590-3 BENT TUBE
(MAKE FROM D2590-101 TUBE)

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MFG. APPR.	DD		SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE 204 SKIDTUBE ASSEMBLY	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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D2590-101 TUBE



DETAIL D
SCALE 5X

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2019 DEC 13

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DRAWN	SAD		
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MFG. APPR.	DD	D2590	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	204 SKIDTUBE ASSEMBLY	NTS
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